

Work Order ID 72898

Page 1

Wednesday, August 17, 2011 2:47:06 PM

Item ID: D4035-045

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (Light)

Stop



Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10/8/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R Aluminum rod Batch: 117889 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut D4035-1 as per dwg D4035
2- Drill holes as per dwg D4035 using DT9619
3- remove identification marks and deburr
4- Weld bushing in rib as per dwg D4035

PL 11-08-23

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72898

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Page 2

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulog/ry



130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD

11-02-25



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CZ11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:47:12 PM

Page 1

Work Order ID: 72898

Parent Item: D4035-045

Parent Item Name: Lid Rib Assembly, Fwd (Light)



Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2953-175 		Manufactured	No			100	Each	16.0000	1	1			
Spacer													

Location Loc Qty Loc Code

WA005	16	
57335	14	
65919	2	

M6061T6TS0.750W.06 2		Purchased	No			100	f	208.1112	1.875	1.973684			
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6061-T6 SQ Tube .75 x .75 x .062W

Location Loc Qty Loc Code

MAT006	20.16379	
104422	4	
116687	1.16379	
9671	15	
MAT013	187.9474	
117400	187.9474	

Pl 11.08.23
B72847 → ①

Pl 11.08.23
1.973684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

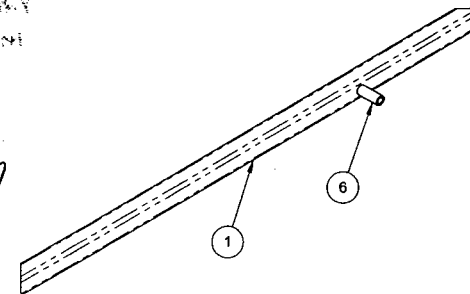
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

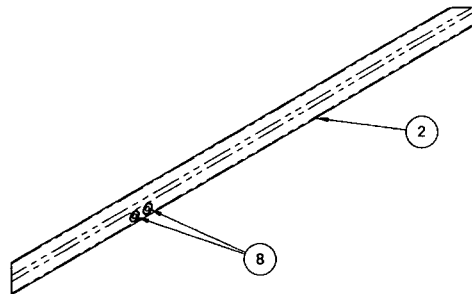
NOTE: Date & initial all entries

SHOP COPY
RETURN TO 4

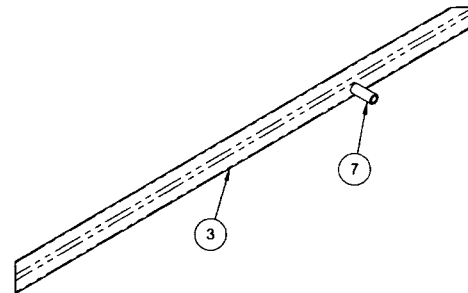
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72898
1411-08-17



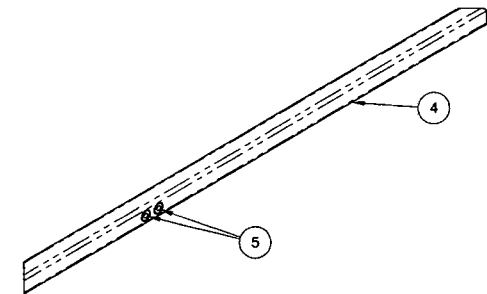
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



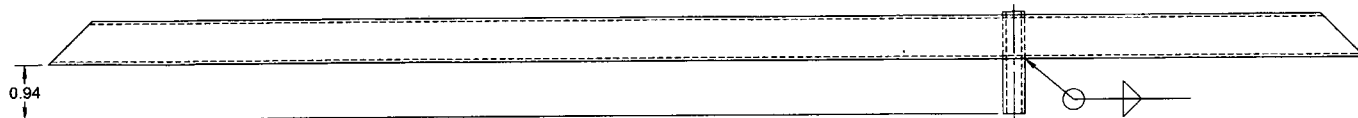
D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D4035	REV. A SHEET 1 OF 5
CHECKED		TITLE BASKET LID RIB ASSY	SCALE NTS
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APPROVED		DATE 10.03.04	
DE APPR.			

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

8 7 6 5 4 3 2 1

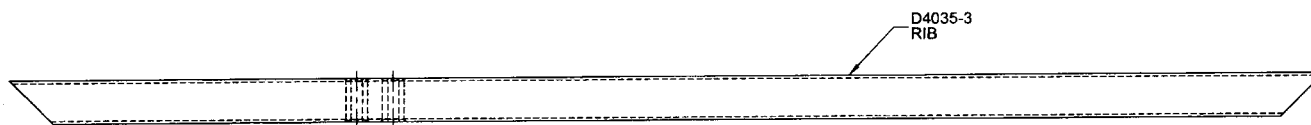


D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY. FWD

72898



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY. AFT

RELEASED
2010-03-12
WDP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO.	REV. A
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

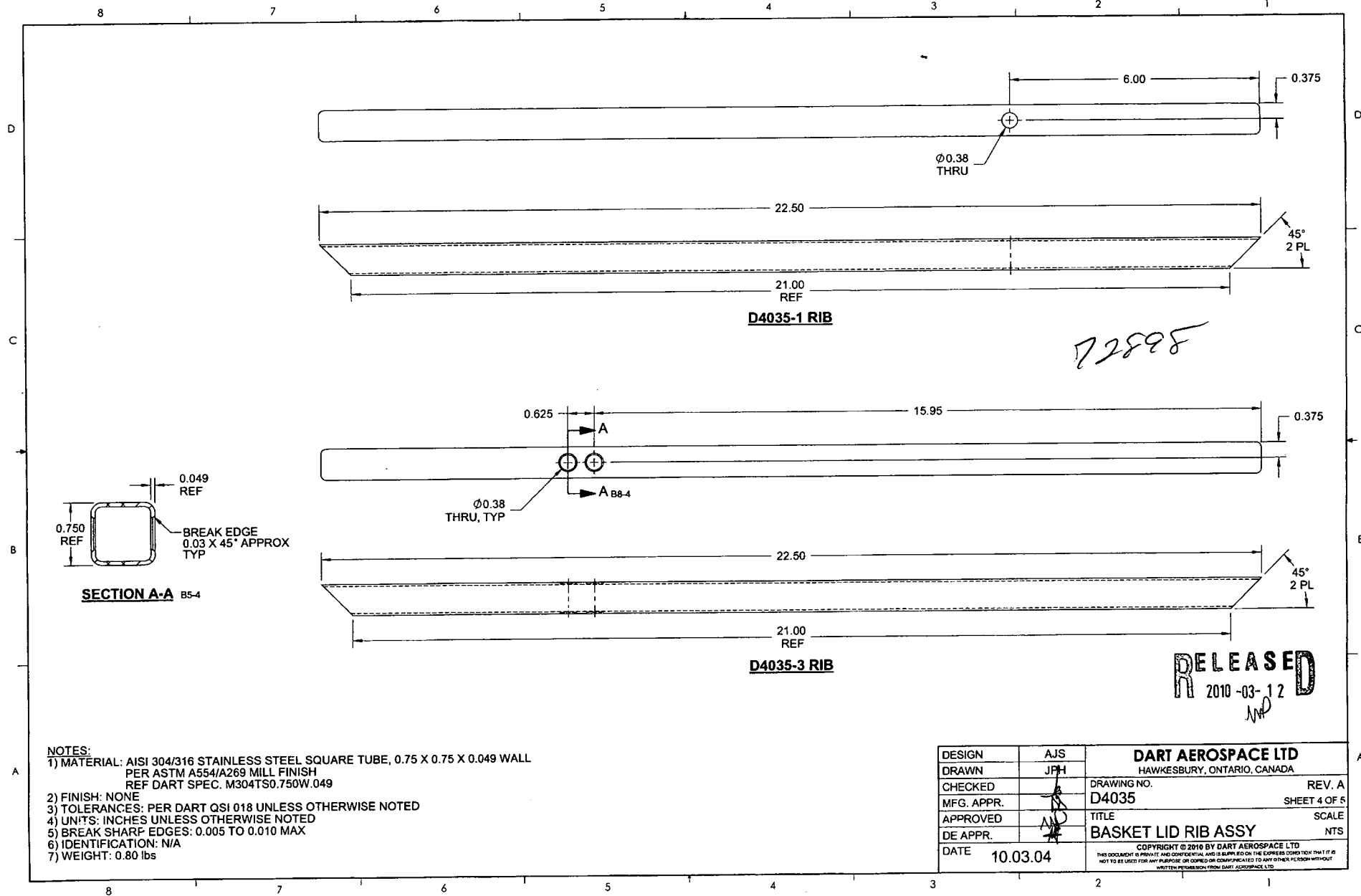
RELEASED
2010-03-12

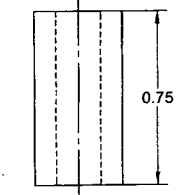
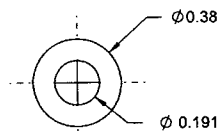
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

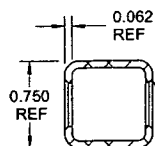
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MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

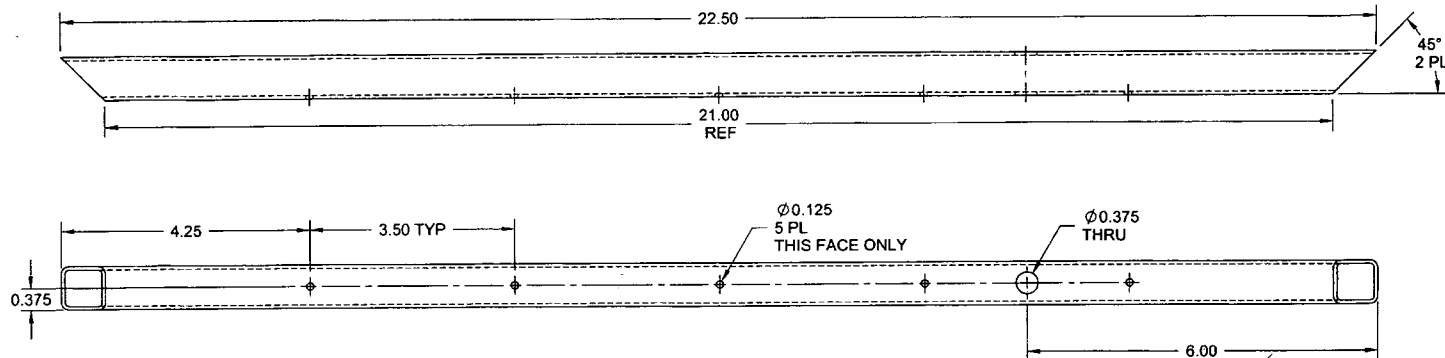




D4035-11 BUSHING

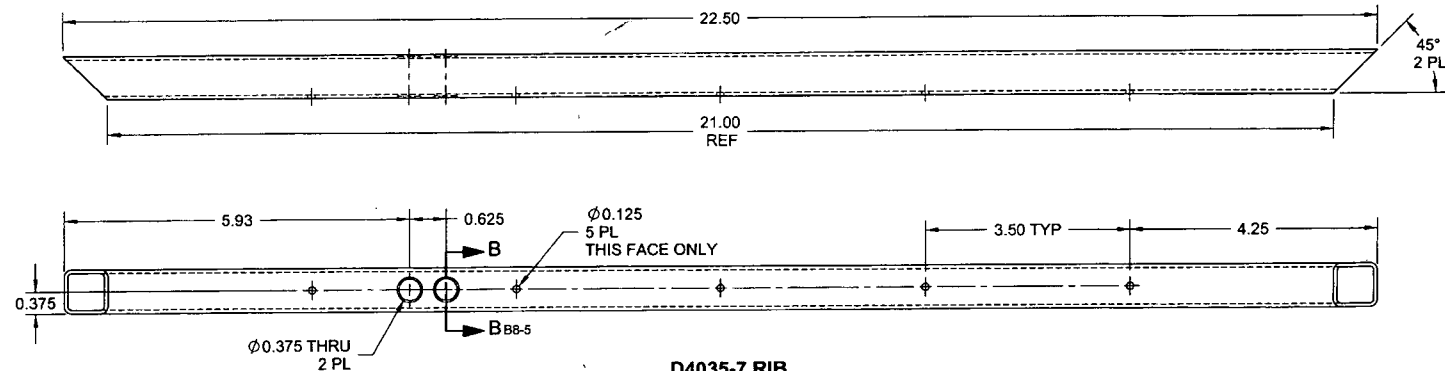


SECTION B-B B5-5



D4035-5 RIB

72898



D4035-7 RIB

NOTES:

- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

RELEASED
2010-03-12
JND

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DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFH	DRAWING NO.	REV. A
MFG. APPR.	JS	D4035	SHEET 5 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET LID RIB ASSY	
DATE	10.03.04	NTS	
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